

# Work Order ID 55394

January 15, 2010 12:53:25 PM



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Item ID: D412-698-013

Accept



Setup Start



Revision ID:

Item Name: Door Handle

Stop



Start Date: 1/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 1/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-1-15 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-013CHG001

MF 10-1-15

810/1/15

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10-1-15 @ SP

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

2) 810/1/15



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Item ID: D412-698-013

Accept

Revision ID:

Item Name: Door Handle

Start Date: 1/15/2010 Start Qty: 1.00

Required Date: 1/15/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D412-698-013 Location: \_\_\_\_\_

0.00

0.00

Reva

10-1-15 R S

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/01/15 J  
MF 10-1-15

# Picklist Print

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Work Order ID: 55394

Parent Item: D412-698-013

Parent Item Name: Door Handle

Comments: IPP Rev: C Removed Manufacturing 05-11-06 JLM  
IPP Rev:D change to rev D ECN 1104 08-01-28 DD

Start Date: 1/15/2010

Required Date: 1/15/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD416L



Washer



10-1-15

SP

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	783	
105078	4	
107008	54	
108583	38	
110153	287	
112492	400	

D3203-1

Manufactured No



Handle

9.0000 4.0000



10-1-15

SP

Warehouse Location	Loc Qty	Loc Code
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Main Warehouse

ST	9	
48565	9	

Manufactured No

D3220-041



Doubler Assembly

4.0000 1.0000



10-1-15

SP

12

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	4	
35568	1	
48565	3	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 55394



Parent Item: D412-698-013



Parent Item Name: Door Handle

Start Date: 1/15/2010

Required Date: 1/15/2010

Comments: IPP Rev: C Removed Manufacturing 05-11-06 JLM  
IPP Rev:D change to rev D ECN 1104 08-01-28 DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3220-042		Manufactured	No				Each	15.0000	1.0000			
										10-1-15		
Doubler Assembly												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

15

46583

6

47442

3

48565C

6

D3220-3

Manufactured No

Each

12.0000

2.0000



Doubler



10-1-15

sp

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

12

48565

12

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 55394



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Parent Item Name: Door Handle

Start Date: 1/15/2010

Required Date: 1/15/2010

Comments: IPP Rev: C Removed Manufacturing 05-11-06 JLM  
IPP Rev:D change to rev D ECN 1104 08-01-28 DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4  Nut		Purchased	No				Each	3,809.000	8.0000		10-1-15	SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	3809	
102552	6	
104248	6	
110507	184	
111827	2613	8
113422	1000	
15924	0	

MS24694-S98



Screw

Purchased

No

Each 260.0000 16.0000

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	260	
111776	10	9
112724	50	7
113644	200	

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS**

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Date: 08.05.01